



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4268-3
Job Sheet 183622



Part No: D4268-3

Job Qty: 4 ea

Part Name: Instrument Panel Assembly (212)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 9/19/18

Created By: Shannon Hadley

Type: SOLD

Description:

Note: DWG REV A SHEETS 5,6 IPP Rev:A 11.02.07 new issue DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	4 pcs		9/19/18	0.00	0.66	Waterjet 1		SC 18/10/18
110	QC	4 pcs		9/19/18	0.00	0.00	QC2 Waterjet-3		SC 18/10/18
120	QC	4 pcs		9/19/18	0.00	0.00	QC8-4		OCT 01 2018
130	Small Fab	4 pcs		9/19/18	0.00	0.40	Small Fab-6		OCT 01 2018
140	QC	4 pcs		9/19/18	0.00	0.00	QC5		OCT 02 2018
150	HandFinish	4 pcs		9/19/18	0.00	0.59	HandFinish1		DR 18/10/18
160	SprayPaint	4 pcs		9/19/18	0.00	0.47	Spray Paint		OCT 06 2018
170	QC	4 pcs		9/19/18	0.00	0.00	QC14		OCT 09 2018
200	Packaging	4 pcs		9/19/18	0.00	0.00	Packaging3-2		OCT 09 2018
210	QC21-SA	4 Ea		9/19/18	0.00	0.00	QC21		OCT 09 2018

Part Op 100 - 1-Cut as per Dwg (D4268-3) Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1- C'sink holes as per dwg 2- Bend as per dwg

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - Spray Painting per QSI005 4.2 Prime per QSI 4.2 and as per dwg Yellow Tempo 138877

170 - QC14- Inspect Spray Paint

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.2976 sf (.0744 ea)	100-Waterjet	5114846

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M2024T3S.040	0	43	0

Part Specifications

Specifications could not be found.

Plex 9/21/18 2:18 PM Dart.Hadley.Shannon

1210 ROBERTSON STREET
CANADA
TEL: 1 813 632-5200
Email: sales@dartero.com
www.darterospace.com

Container No: S114991



Part: D4268-3
Job No: 183622

Serial No/Batch: S114991

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/01/18



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D4268-3**Job Sheet 183000**

Rush!!!

**Part No:** D4268-3**Job Qty:** 4 ea**Part Name:** Instrument Panel Assembly (212)**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/10/18**Job Tracking No:****Due Date:** 9/19/18**Created By:** Jesse White**Type:** SOLD**Description:****Note:** DWG REV A SHEETS 5,6 IPP Rev:A 11.02.07 new issue DD verf:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		9/19/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	4 pcs		9/19/18	0.00	0.66	Waterjet1		
110	QC	4 pcs		9/19/18	0.00	0.00	QC2 Waterjet-3		
120	QC	4 pcs		9/19/18	0.00	0.00	QC8-4		
130	Small Fab	4 pcs		9/19/18	0.00	0.40	Small Fab-6		
140	QC	4 pcs		9/19/18	0.00	0.00	QC5		
150	HandFinish	4 pcs		9/19/18	0.00	0.59	HandFinish1		
160	SprayPaint	4 pcs		9/19/18	0.00	0.47	Spray Paint		
170	QC	4 pcs		9/19/18	0.00	0.00	QC14		
200	Packaging	4 pcs		9/19/18	0.00	0.00	Packaging3-2		
210	QC21-SA	4 Ea		9/19/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg (D4268-3) Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - 1- C'sink holes as per dwg 2- Bend as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - Chemical Conversion Coat per QSI005 4.1
 160 - Spray Painting per QSI005 4.2 Prime per QSI 4.2 and as per dwg
 170 - QC14- Inspect Spray Paint
 200 - Identify as per dwg & Stock Location: _____
 210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.2976 sf (.0744 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	0	43	0

Part Specifications
Specifications could not be found.

Plex 9/10/18 11:30 AM dart.white.jesse

DART AEROSPACE LTD		Work Order: 183622
Description: Instrument Panel		Part Number: D4268-3
Inspection Dwg: D4268	Rev: A	Page 1 of 1

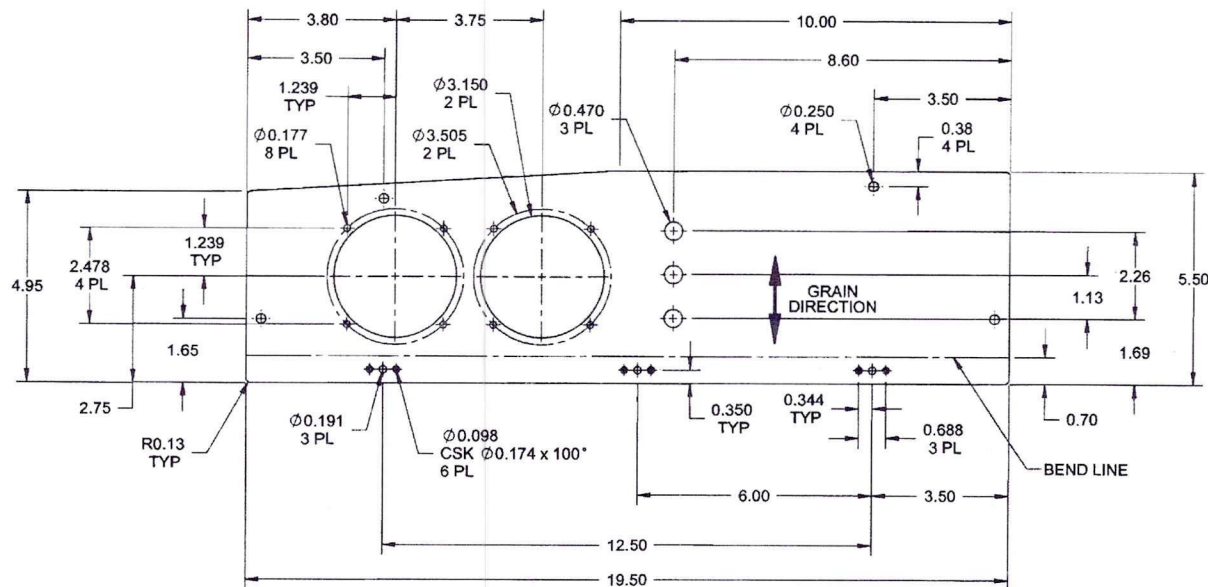
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.100	1		VSC-01	
Ø0.177	+0.005/-0.001	Ø0.180	1		Tape	
Ø0.191	+0.005/-0.001	Ø0.192	1			
Ø0.250	+0.005/-0.001	Ø0.252	1			
Ø0.470	+0.006/-0.001	Ø0.471	1			
Ø3.150	+0.012/-0.001	Ø3.152	1			
Ø3.505	+0.012/-0.001	Ø3.507	1			
4.95	+/-0.030	4.954	1			
2.478	+/-0.010	2.480	1			
1.239	+/-0.010	1.240	1			
1.65	+/-0.030	1.655	1			
2.75	+/-0.030	2.756	1			
19.50	+/-0.030	19.503	1			
12.50	+/-0.030	12.507	1			
6.00	+/-0.030	6.00	1			
3.50	+/-0.030	3.508	1			
0.350	+/-0.010	0.348	1			
0.344	+/-0.010	0.342	1			
0.688	+/-0.010	0.685	1			
1.69	+/-0.030	1.698	1			
1.13	+/-0.030	1.134	1			
2.26	+/-0.030	2.257	1			
5.50	+/-0.030	5.483	1			
0.38	+/-0.030	0.387	1			
3.50	+/-0.030	3.498	1			
8.60	+/-0.030	8.602	1			
10.00	+/-0.030	10.00	1			
3.80	+/-0.030	3.799	1			
3.75	+/-0.030	3.754	1			
3.50	+/-0.030	3.501	1			
1.239	+/-0.010	1.240	1			
0.040	+/-0.010	0.038	1			

DAS
68
9-88
OCT 01 2018

Measured by: SC	Audited by:	Preliminary Approval:
Date: 18/10/01	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	KJ	



D4268-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

RELEASED
2011-04-06

NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.35 lbs

1050

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	11.02.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE KEPT AND ONLY THE SUPPLIER'S CONSIDERATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	